

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024051**Date Inspected:** 09-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 5

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening on traveler rail assembly. ZPMC QC inspector Xu Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Li Zhi Jiang as the CWI. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10291

3025TR1-001-003~011

Bay 7

This QA inspector observed ZPMC in process of welding on cantilever box beam assembly. ZPMC CWI Liu Fa Wen was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder operator and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BKSA015-001-016

WPS-B-T-2221-TC-U4a-S-2

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Welder- 044771

1G/SAW/CJP

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening on traveler rail assemblies. ZPMC QC inspector Zhu Zhang Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Chen Shi Gang as the CWI. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10262

3014TR2-002-003, 004

Heat Straightening

HSR1 (B) 10249

3016TR3-001-005, 006

Trial Assembly

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09080 Item 11 on OBG 14E assembly. This QA Inspector performed verification Visual Inspection (VT) and Magnetic Particle Testing (MT) inspection after ZPMC had performed their MT inspection of the following locations;

SEG3019L-001, 247, 248, 249, 251, 252, 253, 255, 256, 257, 259, 260, 261, 263, 264, 265, 267, 268, 269, 271, 272, 273, 275, 276, 277, 279, 280, 281

SEG3019K-219, 221, 223, 225, 227, 229, 231, 233, 235

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 05-09-2011 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

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Inspected By: Hasler, Mike

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer